

Date: Friday, 9/14/2007 2:01:49 PM  
 User: Kim Johnston

## Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CROSSTUBE EXTRUSION (206L)
Job Number : 34684	
Estimate Number : 10025	
P.O. Number : N/A	Part Number : D6002115
This Issue : 9/14/2007 S.O. No. : N/A	Drawing Number : D6002 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 29113	Material : N/A
Written By : _____	Due Date : 1/30/2008
Checked & Approved By : <u>8/27/09.17</u>	Qty: 27 Um: Each
Comment : Est Rev:B 00.12.15 Added: Issue P/O EC	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O

4611

CLO 7/09/18

a) Extrude as per Dwg D6002

b) Material: 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9

or QQ-A-200/11 ) seamless aluminum tube

c) Minimum ultimate tensile strength = 77 ksi

d) Minimum tensile yield strength = 66 ksi

e) Material certification required

(27)

2.0

D6002115P

Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 27.0000 Each(s)

Crosstube material

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

P

8/1/03

(30)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6002

5/8/01/04

(30)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: D Date: 08/01/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:01:49 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSTUBE EXTRUSION (206L)

Job Number: 34684

Part Number: D6002115

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MAT-26

J.F.

08/01/04

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208/01/04 (30)

Job Completion



in 2008/1/4  
W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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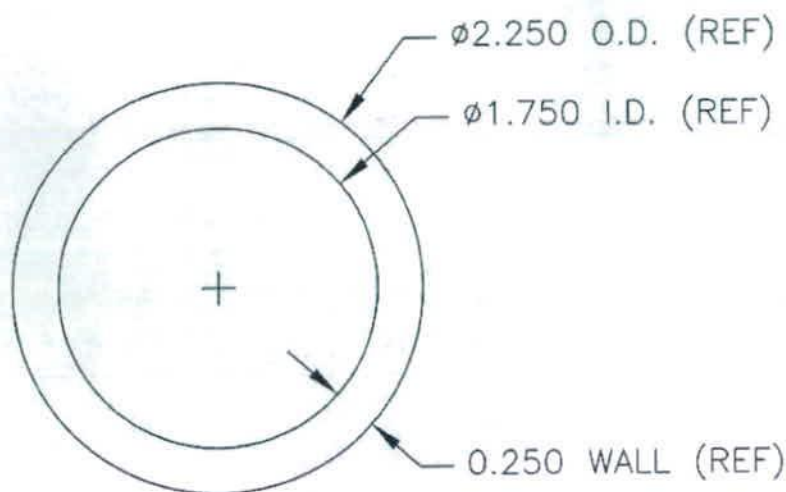
NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D6002	REV. A SHEET 1 OF 1
DATE 00.11.22		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	00.11.22	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
00.11.24



### NOTES

- 1) D6002-XXX CROSSTUBE  
LENGTH

WHERE XXX IS LENGTH IN INCHES  
EG. 115" LONG TUBE: D6002-115

- 2) MATERIAL: 2.250 OD x 0.250 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.  
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi  
MINIMUM YIELD TENSILE STRENGTH = 66 ksi

- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:  
O.D.:  $\pm 0.006$  MEAN ( $\pm 0.012$  INCLUDING OVALITY)  
WALL:  $\pm 0.008$  MEAN ( $\pm 0.025$  INCLUDING ECCENTRICITY)  
LENGTH: XXX  $+0.125/-0.000$   
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.  
5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 34684

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